

# Work Order ID 73591 - 2

Tuesday, September 06, 2011 11:12:38 AM



Item ID: D3436-043

Revision ID:

Item Name: Step 1.11

Start Date: 9/6/2011

Required Date: 9/9/2011

Reference:

*split ✓*

Accept



Setup Start



Stop



Cust Item ID:

*AC330D*

Customer:

Approvals: Process Plan: *JKF*  
QC:

Date: *11-07-09* Tooling:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Draw Nbr

D3436

100



Large Fab

Operation  
Description  
Revision Nbr

Rev A

Large Fab

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

0.00

0.00

0.06

0.00

1. Slit part D3436-041 on bandsaw as per Dwg D3436  
debut

2.

110



Bandsaw

BAND SAW

0.00

Jeaspa Bandsaw

Memo

0.00

*EL 11-9-8 (x2)*

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*EL 11-9-8 (x2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 73591

Tuesday, September 06, 2011 11:12:38 AM



Page 2

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011

Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011

Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan

Accept

Reject

Reject

Number

Insp.  
Stamp

8/16/08

62

44

140



Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Wing Walk batch:

183/3

100

400

05

183/3

0.00

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

OK 11-2-12 (2)

264 6/10/12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Work Order ID 73591

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Item ID: D3436-043

Accept



Setup

Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

155



Small Fab

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

0.00

0.00

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sulog/12

(H)  
(L)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 1X8A

0.00

Memo

0.00

11/9/12 SLR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 73591**

Tuesday, September 06, 2011 11:12:38 AM



Page 4

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation:  
Description  
180  
  
QC  
Quality ControlSet Up/  
Run HoursTool ID  
Tool #Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp,  
Stamp

0.00

0.00

0.00

11/9/13 JJ

MF  
11-89-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Tuesday, September 06, 2011 11:12:34 AM

Page 1

Work Order ID: 73591



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 9/6/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.05.11 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3436-1



Manufactured

No

100

Each

41.0000  
1

2

EL 16-9-7

Clamp

Location	Loc Qty	Loc Code
----------	---------	----------

WA021

17679

41

41

100

Each

0.0000

1

2

2

D3436-3



Manufactured

No

100

Each

0.0000  
1

2

EL 11-9-7

Left Step

D3436-5



Manufactured

No

100

Each

20.0000  
4

8

EL 16-8-7

Bushing

Location	Loc Qty	Loc Code
----------	---------	----------

ST

46592

20

160

Each

43.0000

1

2

7

D3436-7



Manufactured

No

160

Each

43.0000  
1

2

EL 11-9-7

Cap

Location	Loc Qty	Loc Code
----------	---------	----------

WA021

56836

43

43

2

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

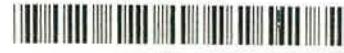
Tuesday, September 06, 2011 11:12:35 AM

Page 2

Work Order ID: 73591



Parent Item: D3436-043



Parent Item Name: Step 1.11

Start Date: 9/6/2011

Required Date: 9/9/2011

123436-9



Pad

Manufactured No

100

Each

12.0000

2

4



SD 10/09/11

Location	Loc Qty	Loc Code
GA	8	
56830	2	
69599	6	2
ST053	4	
66567	4	

B-73467

+

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

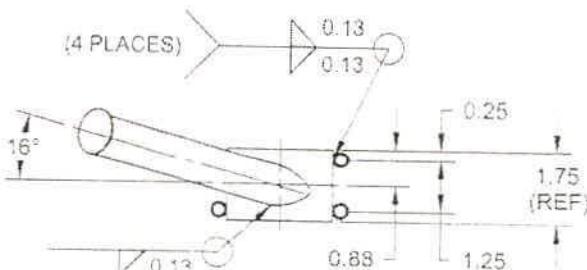
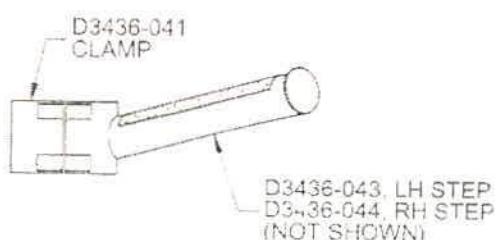
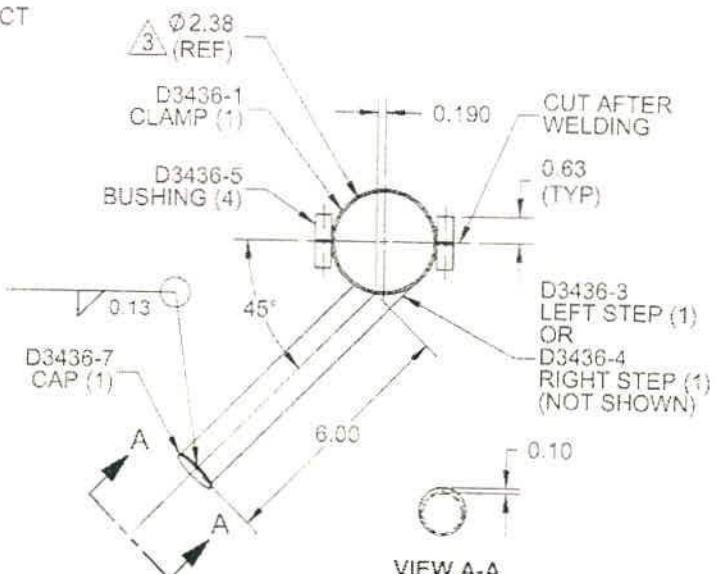
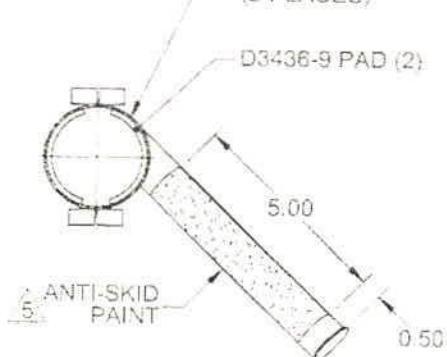
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB		DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436		REV. A	SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP		SCALE	1:4
A	05.04.28	NEW ISSUE			

BOND WITH CONTACT  
CEMENT PER  
MANUFACTURER'S  
SPECIFICATION  
12 PLACES



#### NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELATION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

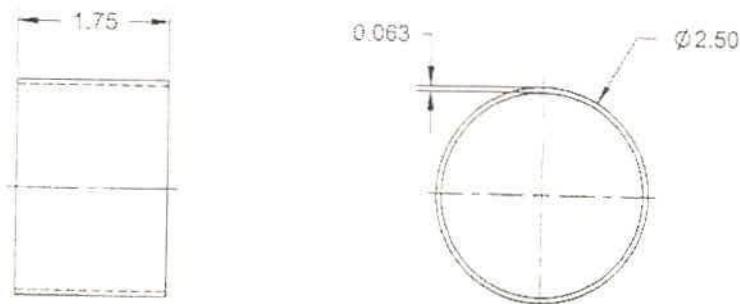
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**DART**

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2

**D3436-1 CLAMP**

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)

**D3436-5 BUSHING**

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

**RELEASED**05-25-27 *MM***D3436-1/ -5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

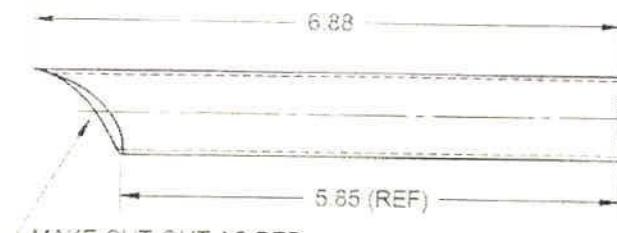
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

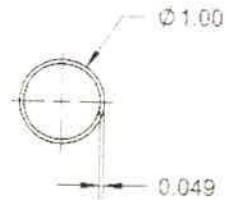
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:2	



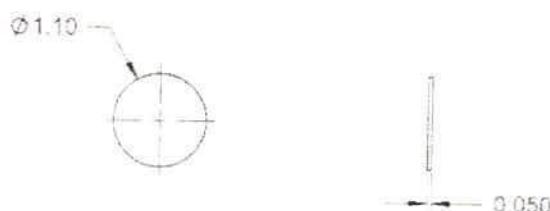
MAKE CUT-OUT AS PER  
TEMPLATE DT8771



### D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



### D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

### D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

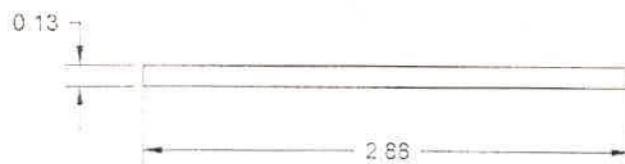
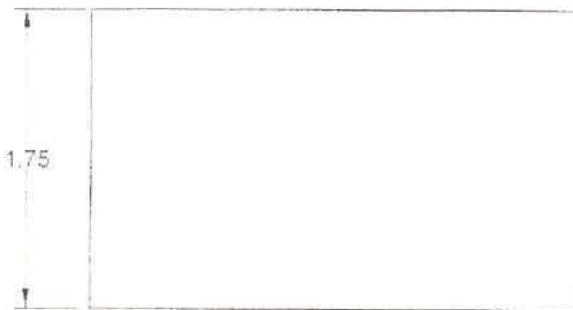
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NOTE: Date & initial all entries



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CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV A	SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1	



RE  
05.05.27 *MM*

### D3436-9 PAD

#### NOTES:

- 1) MATERIAL 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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